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D4018-041
Job Sheet 193648



Part No: D4018-041

Job Qty: 1 pcs

Part Name: AS350 Short Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No: 14390

Due Date: 5/17/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG D4020 REV A, D4018 REV E SHEETS 1,2,3 IPP RevA: new issue DD 09.11.30 verified by:EC IPP
Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	5/17/19		0.00	7.69	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	5/17/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS 43 9-89
							QC 9 - 50		
120	QC 5	1 pcs	5/17/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS 43 9-89
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	5/17/19	0.00 0.42			Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	B219-5-7.
						Powdercoat - 4 - B4B	
140 Handfinish - 3-1- WingWalk-B4B	1 pcs	5/17/19	0.00 0.88			Handfinish - 3 - 1 - B4B	all 19-5-7
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	5/17/19	0.00 0.00			QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	DAS
						QC 3 - 30	19
						QC 3 - 34	9-09
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
160 Packaging 3-1 - Stock - B4B	1 pcs	5/17/19	0.00 0.00			Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						</	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	5/17/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21 MAY 08 2019
				QC 21 - SA - 53	0-00

Part Op **100** - (Weld per dwg A/R S.S. rod Batch: 138881) 1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D4018 ***inspect before welding mesh*** 3- Cut mesh as per dwg D4020-7 4- tack weld mesh on basket as per dwg D4018 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** mask sides of hinge prior to powdercoat***

140 - (Wing Walk as per dwg QSI005 4.4 Batch_____) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location:_____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket ✓	2 pcs (2 ea)	100-Large Fab - Basket - 1	5161219
D4016-3	Hinge Half, Lid ✓	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110932
D4018-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5173614
D4018-3	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5173596
D4018-5	Rib ✓	6 pcs (6 ea)	100-Large Fab - Basket - 1	2x 5156244 4x 5172268
D4021-3	Data Plate ✓	1 pcs (1 ea)	100-Large Fab - Basket - 1	5154112
D4035-043	Lid Rib Assembly, Aft (350 Basket) ✓	2 pcs (2 ea)	100-Large Fab - Basket - 1	5168875
M304EX0.75-16F	Expanded Metal Flat SS ✓	16 sf (16 ea)	100-Large Fab - Basket - 1	5147879

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	27	0
	D4016-3	3	72	0
	D4018-1	2	0	0
	D4018-3	2	0	0
	D4018-5	6	52	0
	D4021-3	1	49	0
	D4035-043	2	6	0
	M304EX0.75-16F	16	1,112	0

Part Specifications

Specifications could not be found.



Container No: S175603



Part: D4018 - 041

Job No: 193648

Serial No/Batch: S175603

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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